3												
	er ID 64792 er 17, 2010 7:55.											Page
Item ID: Revision ID:	D3296-041				Accept				s s	etup Star	·t	
Item Name:	Door Assembly	10	·					*		Stop	P	
		art Qty;_6.00	-			Cust Item	ID:					
Required Date: Reference:	1/19/2011 Re	eq'd Qty: 6.00				Customer:						
Approvals:	Process Plan: _	Q/	Date:	10/211	Tooling:	D	ate:		R	tun Star	i ibatilli i	
	QC:		Date:_		<b>SPC (Y/N):</b>	D	ate:			Sto	p	
Sequence ID/ Work Center ID		eration scription			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisior	ı Nbr										
D3296	Rev A							,				
	Sma	all Fab			0.00					1/2	/ =	(Ta
Small Fab Small Fab		Memo Enhaicete	P. assauthle as	D D220	0.00			/			70 <u> </u>	- ( )
Sman I au			& assemble as	per Dwg D3296 70 & DT9521	5.				·			
	QC	5- Inspect part com	npleteness to ste	ep on W/O	1,, 2 00.0	orlos			(+10)			
QC Quality Control		Memo			0.00	• •			710			-

120

Powdercoat Powder Coating Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

10 BR 11-02-8.

0.00

# **Dart Aerospace Ltd**

- 4				•						
W/O:			W	ORK ORDER CHANGE	S					
DATE	STEP	PRO	CEDURE CHA	NGE	В	y I	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
									• •	
										,
								}		
Part No		PAR #:								
	R	esolution:	Disposition	on:	QA: N	/C Clos	sed:		Date:	
NCR:			WORK ORE	DER NON-CONFORMAN	NCE (	NCR)				,
DATE	STEP	Description of NC		Corrective Action Section		Sign &		cation	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng		Date	Sect	ion C	Chief Eng	QC Inspector
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							Page 2
			s s	etup	Start Stop		
Cust Item I Customer:	D;						
	ate:		R	lun	Start Stop		
Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty	, ]	Reject Number	Insp. Stamp

140 Small Fab

Reference:

Approvals:

Sequence ID/

Quality Control

130

**Work Center ID** 

Small Fab

Process Plan:

Operation

Description

QC3- Inspect Part Finish

Memo

Memo

0.00

0.00

Accept

Tooling:

0.00

0.00

SPC (Y/N):

Set Up/

**Run Hours** 

Assemble as per Dwg D3296

Date:\_\_\_\_\_

Date:

ESu/02/09 (0)

150

Small Fab

QC5- Inspect part completeness to step on W/O

0.00

Memo

00

Stille 2/09

Quality Control

0.00

# **Dart Aerospace Ltd**

	1								
W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								·	
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No D	QA:	Date: _	
	Re	esolution:	Disposition	:	_ QA: N/C	Closed: _		Date: _	<del></del>
NCR:	·		WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section		Ver	ification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign Dat	&   S	ection C	Chief Eng	QC Inspector
				<u> </u>					

### Work Order ID 64792

Friday, December 17, 2010 7:55:32 AM



Page 3

Item ID:

D3296-041

Accept

Accept

Qty

Setup Start

Stop



**Revision ID:** 

Item Name:

Door Assembly

**Start Date:** 

12/16/2010

Start Qty: 6.00

Required Date: 1/19/2011

Req'd Qty: 6.00



**Cust Item ID: Customer:** 

Reference:

**Approvals:** 

Process Plan:

QC:

Date:

Date: Tooling:

SPC (Y/N):

Set Up/

Tool ID

Date:

Tool # Plan

Code

Date:

Run

Reject

Qty

Start

Stop



Insp.

Stamp

Sequence ID/

Work Center ID

160

170

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 213

Run Hours

0.00

Memo

0.00

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Reject

Number

M/02/10 10 MF 11-02-09

Dart Aerospac	e Ltd
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W/O:			W	ORK ORDER CHANG	ES				1
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								•	
Part No		PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Dispositi	on:	_ QA: N/C C	osed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (NC	<b>?</b> )			
DATE	CTED	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		tion C	Chief Eng	QC Inspector
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# **Picklist Print**

Friday, December 17, 2010 7:55:37 AM

Work Order ID: 64792

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Parent Item: Di

D3296-041

Parent Item Name: Door Assembly



Start Date: 12/16/2010

Required Date: 1/19/2011

Date

Issued

Page 1

Status

Start Qty: 6.00

Required Qty: 6.00

	PP C□05.10.14□ PP Rev:D Revis	Added step 14□K ed Steps 06-11-2									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued
D3161-7 Hinge 14.0"		Manufactured	No			100	Each	6.0000			c2
				Location ST038		<u>Loc (</u>	<u>Qty</u> 6	Loc Code			1

			ST038 63596		6	•
D3161-9  Hinge 17.0"	Manufactured	No	. \$	. 100	Each	4.0000
-			Location	Loc	<u>Qty</u>	Loc Cod

No

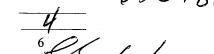
Manufactured

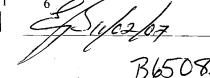
		<b>Location</b>	Lo	c Oty	Loc Code	
		ST040		4		
		63344		4		
Manufactured	No		100	Each	1.0000	
		Location	<u>Lo</u>	c Oty	Loc Code	
		ST186		1		
		57975		1		

<b>Location</b>	Loc Qty	Loc Code
ST186	10	
59639	10	

100

Each





6 / 511/02/07

10

10.0000

D3296-1

Door Panel

D3296-3

Door Panel

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# **Dart Aerospace Ltd**

W/O:			W	ORK ORDER	CHANGES					
DATE	STEP	PRO	CEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
٠								,		
Part No		PAR #:								
•	R	esolution:			•				Date: _	
NCR:		V	VORK ORE	ER NON-CO	NFORMANC	E (NCR	)			
DATE	OTED	Description of NC		Corrective Acti			Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action De	scription Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
								•		

Friday, December 17, 2010 7:55:37 AM

Work Order ID: 64792 Parent Item: D3296-041 Parent Item Name: Door Assembly Start Date: 12/16/2010 Required Date: 1/19/2011 Start Qty: 6.00 Required Qty: 6.00 MS20470AD4-6 Purchased No 100 Each 3,641.000 Rivet, Universal Head Location Loc Qty Loc Code ST319 3030 E 10 116391 3030 ST320 611 114988 611 NAS1149DN632 Purchased AN960JD6 No 140 Each 436.0000 Washer Location Loc Qty Loc Code ST347 436 104537 436 D2137 Manufactured No 140 Each 12.0000 Decal - No Step Location Loc Qty Loc Code ST006 12 59395 2 62071 10 D2419 Manufactured No 140 Each 21.0000 Handle Location Loc Qty Loc Code ST014 21 63423 21

Dart Aerospace
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W/O:		<b>5</b>	N	ORK ORDER C	HANGES					
DATE STEP		PROC	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					?					
							٠.			
									·	
Part No	):	PAR #:	_ Fault Ca	tegory:	NC	CR: Yes	No DQ	A:	Date: _	
		esolution:	Disposition: C				QA: N/C Closed:			
NCR:		W	ORK OR	DER NON-CONF	ORMANC	E (NCF	<b>?</b> )			
		Description of NC	Description of NC Corrective Act		Section B	· · · · · · · · · · · · · · · · · · ·			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Desc Chief En		Sign & Date	🙎   Secti	Verification Section C	Chief Eng	QC Inspector
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# **Picklist Print**

Friday, December 17, 2010 7:55:37 AM

Work Order ID: 64792

Parent Item:

D3296-041

Parent Item Name: Door Assembly



**Start Date:** 12/16/2010

Required Date: 1/19/2011

Page 3

Start Qty: 6.00

Required Qty: 6.00

D2462

Seal

Manufactured

140

603.6009

0.3333

Loc Code

3.333

D2728-1

Manufactured

No

48530

140

140

Each

0.0000

Dart Logo label

Purchased

No

Location

ST404

Each

Loc Oty

603.6009

603.6009

6,314.000

Rivet, Universal Head

MS20470AD4-4

<u>Location</u>	Loc Oty
ST319	6314
112314	30
113368	92
116188	2556
116391	3636

Loc Code

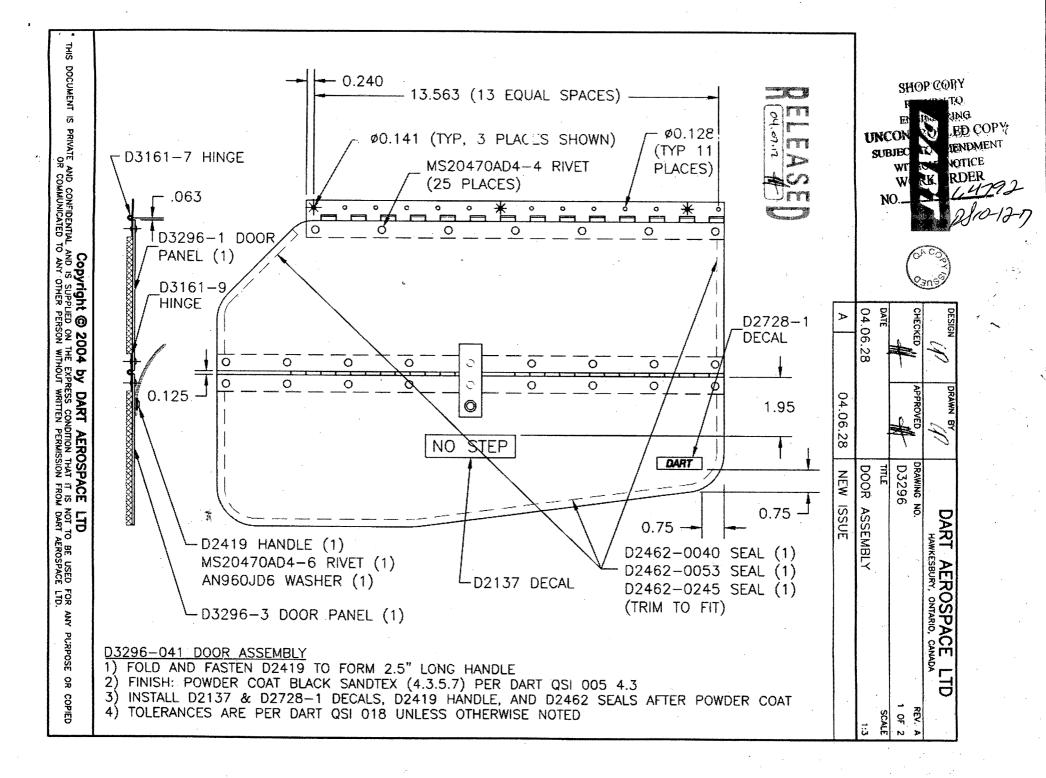
Da	art	Aer	OS	pace	Ltd
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W/O:			W	ORK ORDER CHANC	GES					-	
DATE STEP PROCE			CEDURE CHA	CEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
1											
,										·	
Part No	:	PAR #:	Fault Cate	egory:	NCF	R: Yes	No DQ	A:	Date: _		
Resolution:			Disposition: Q			QA: N/C Closed: Date:					
NCR:		\	WORK ORE	ER NON-CONFORM	ANCE	(NCR	)				
	T	Description of NC	Corrective Action Section B			Verification		cation	1 Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		on C	Chief Eng	QC Inspector	
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		ANNUAL									
					•						
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DART AEROSPACE LTD	Work Order:	44792
Description: Door Panel	Part Number:	D3296-1
Inspection Dwg: D3296 Rev: A		Page 1 of 1

	FIRS1	ARTICLE I	NSPECTI	ON CH	ECKLIST		
	X	First Arti	cle	Prof	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Corr	ıments
5.08	+/-0.030						
R0.06	+/-0.030						
0.300	+/-0.010						
Ø0.128	+0.005/-0.000						
16.400	+/-0.005						
0.300	+/-0.010						
13.400	+/-0.005						** ** **
17.00	+/-0.030		,				
14.18	+/-0.030						
0.300	+/-0.010						
0.063	+/-0.010						
						<u></u>	
						~~~~	
•							**
		transport Test to					
Measured by:		Audited by:			Prototype App		N/A
Date:		Date:				Date:	N/A

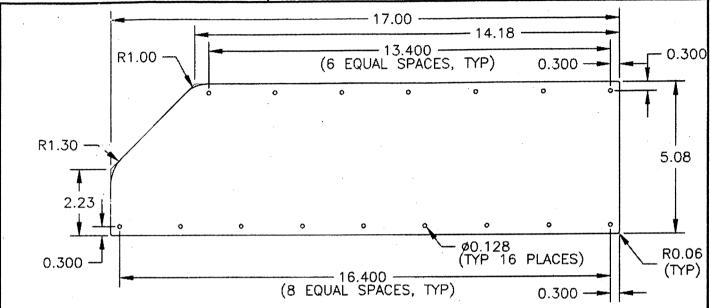
Rev	Date	Change		Revised by	Approv <i>e</i> a
Α	04.08.24	New Issue	P/O D3296-041	KJ/JLM	
				 	/~/



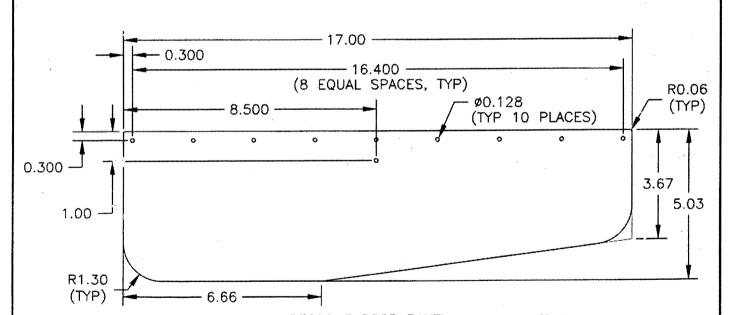




DESIGN (	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
#	<del>       </del>	D3296	2 OF 2
DATE	<u> </u>	TITLE	SCALE
04.06.28		DOOR ASSEMBLY	1:3



### D3296-1 DOOR PANEL



#### D3296-3 DOOR PANEL

D3296-1 AND D3296-3

1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF DART SPEC. M2024T3S.063)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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